

Date: Tuesday, 08/04/2008 4:58:17 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 38491
 Estimate Number : 12485
 P.O. Number :
 This Issue : 08/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : LANDING GEAR
 Previous Run : 38490
 Written By :
 Checked & Approved By : JD 08.4.09
 Comment : Est Rev:A New Issue 06-07-05 JLM
 Est Rev:B Update qty of MS21042L5 06-09-12 KJ
 Est Rev:C Rev B 07-11-15 DD
 Est Rev D Combined manufacturing 08.04.02 EC verified by:
 DD

Drawing Name : 350/355 AS X-TUBE FWD
 Part Number : D350748101
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : B/A 08/06/24
 Material :
 Due Date : 30/06/2008 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD350-748-101 CHG001



2.0 D350748141TRN CROSSTUBE TURNING DETAIL



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch

1340099 42421

DP

8-10-2
8-9-30

3.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT



4.0 QC15 DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES



5.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs,
 Set-up drill table as per QSI 010

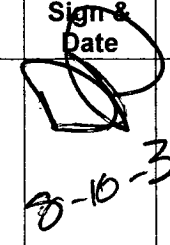
2-Deburr

8T 08-1006

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 08/10/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.10.03	3	Tube is bent high (23.52").	CP 08.10.03 per QSI 042	Cut at 23.375" height. Tube OK	 0-10-3	S 08/10/03 per QSI 042	CP 08.10.03 per QSI 042	S 08/10/03 per QSI 042

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:58:17 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 38491

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Engrave Part # and Batch # as per Dwg D350-748-141 *RT 08-10-06*

4-Remove all marks from tube within limits of D350-748-141 *- AWM 8-10-06*

5- Apply a light coat of LPS3 on the interior of tube

Batch: *102'9/2*

RT 08-10-07

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CHECK 10 DEG HOLES WITH DT8876E(EUROCOPTER CLAMP)

Soot/07

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: *7326*

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

C/L 8/10/07 ①

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

RT 8/21 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soot/07 ①

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Prime Outside of Tube as per Dart QSI 005 4.2

RT 08-10-22

(P/S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:58:17 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 38491

Part Number: D350748101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	QC14	INSPECT SPRAY PAINT
------	------	---------------------



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

RT 08-10-23

12.0	D35021	SUPPORT
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SUPPORT

Batch: 35783

RT 08-10-23

13.0	D2856400	Abrasion Strip
------	----------	----------------



Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 37667

RT 08-10-23

14.0	ALS41032225	Insert
------	-------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: 100621

RT 08-10-23

15.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: 109059

RT 08-10-23

16.0	MS2192020	Clamp (per MIL-DTL-8783C)
------	-----------	---------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 107501

RT 08-10-23

17.0	MS27039110	Screw
------	------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: 18836

RT 08-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:58:17 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 38491

Part Number: D350748101

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

18.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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(Ph)

Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

RT 08-1023

19.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/10/28 (X)

20.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0	D35001	350 SADDLE
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

350 SADDLE

Batch: 35781x2 B36016x2

SS 08/10/28 (X)

22.0	D35011	BUSHING
------	--------	---------



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

BUSHING

Batch: 35781x2 B36016x2

35316

SS 08/10/28 (X)

23.0	AN46A	Bolt
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Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Batch: M108558

SS 08/10/28 (X)

24.0	AN441A	bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

bolt

Batch: M106302x6 M109061x2

SS 08/10/28 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-101 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: D Date: 08/10/27
 QA: N/C Closed: KJ Date: 08.11.04

NCR: <u>38491</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/27	18.	Durkling inspection a large Run was found in the paint.	08.10.27	Mask all clamps and abrasion strips.	ST 08/10/28	08/10/27	08.10.28	08/10/24
		After from Attention to remove the Run employee noticed that he had gone down to the primer R.C. painter wet sanded too much		Scuff with 320 grit sand paper and re paint as per QS2005	ST 08/10/28	08/10/28		
				Re inspect Paint	QC14	08/10/28		

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:58:17 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 38491

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109061

SS 08/10/28 (X)

26.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M108827

SS 08/10/28 (X)

27.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M109059

SS 08/10/28 (X)

28.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M108145

SS 08/10/28 (X)

29.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M108827

SS 08/10/28 (X)

30.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/10/28 (X)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-101

Location:

PPP Rev: B

SS 08/10/28 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:58:17 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 38491

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
D 08/10/09

Job Completion



U 840-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

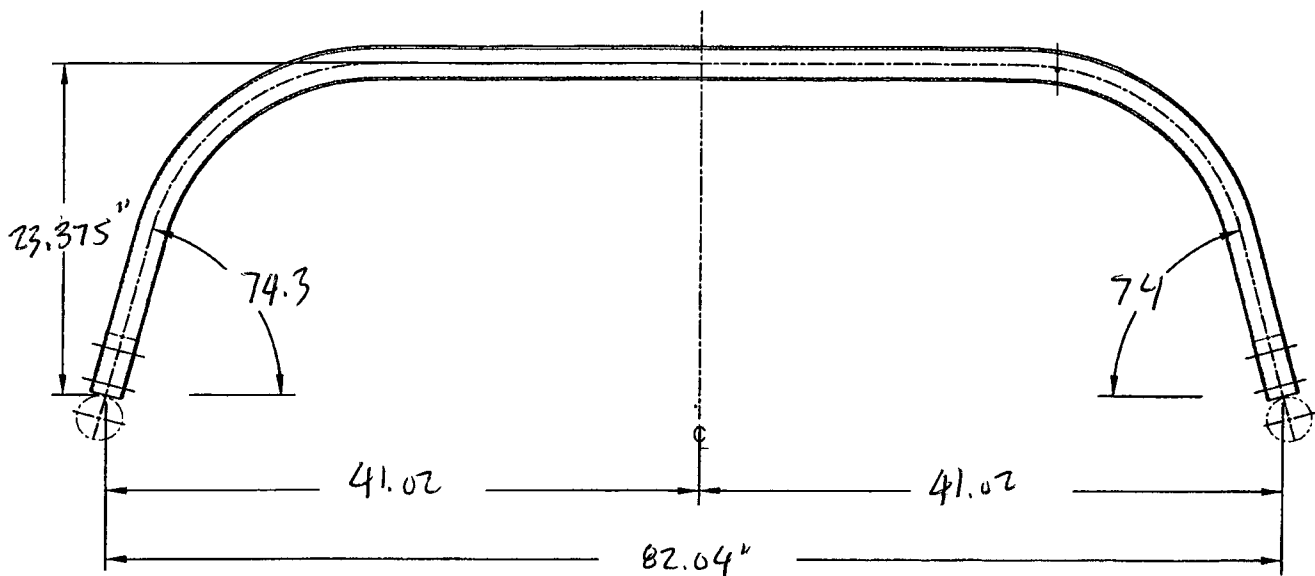
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38491
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
Height is 23.52". Cut @ 23.375"

QC15 Inspection	<i>Q</i>
Date	08.10.03

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

DART

RELEASED

06.10.31

DESIGN <i>92</i>	DRAWN BY <i>92</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>11</i>	APPROVED <i>11</i>	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125
FINISHED LENGTH = 110.27±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

UNDER REVIEW!

07.02.16

CUTTING REDUCED
07.07.22

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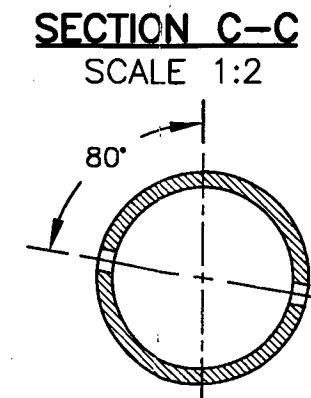
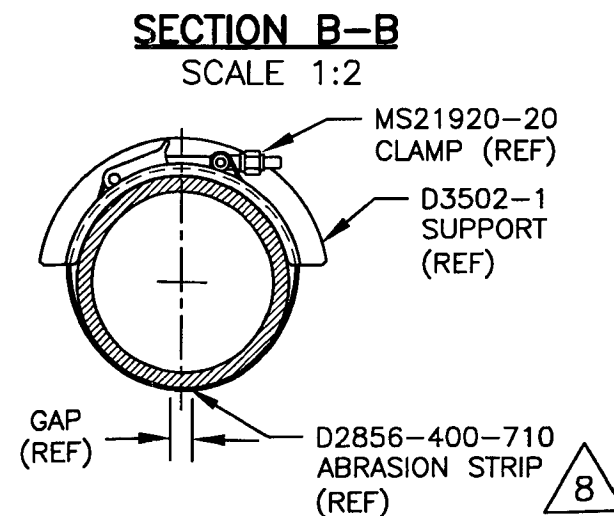
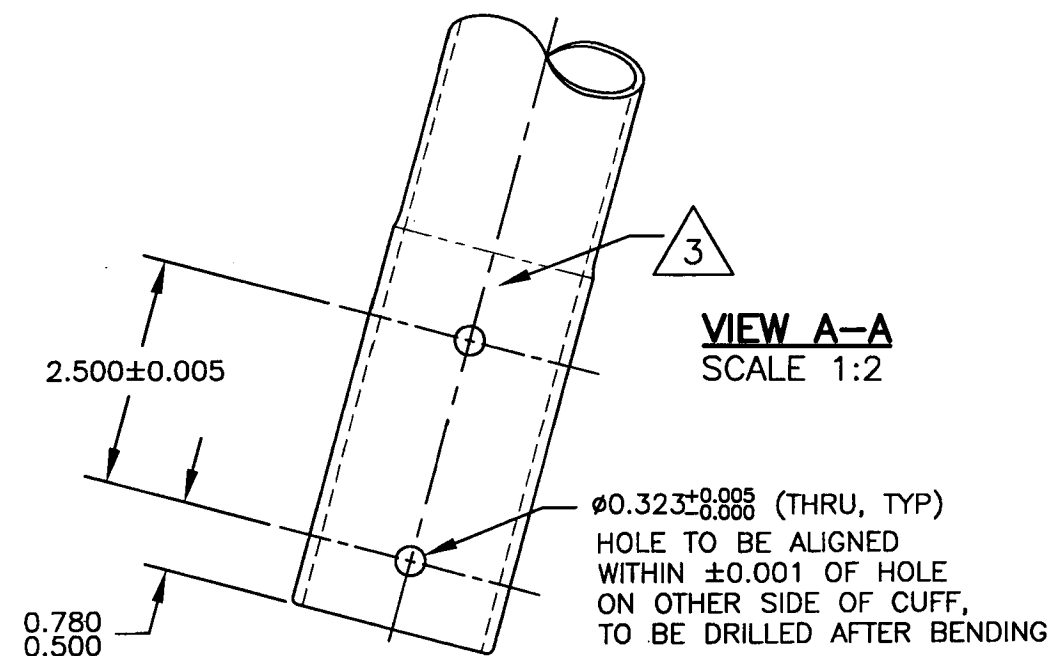
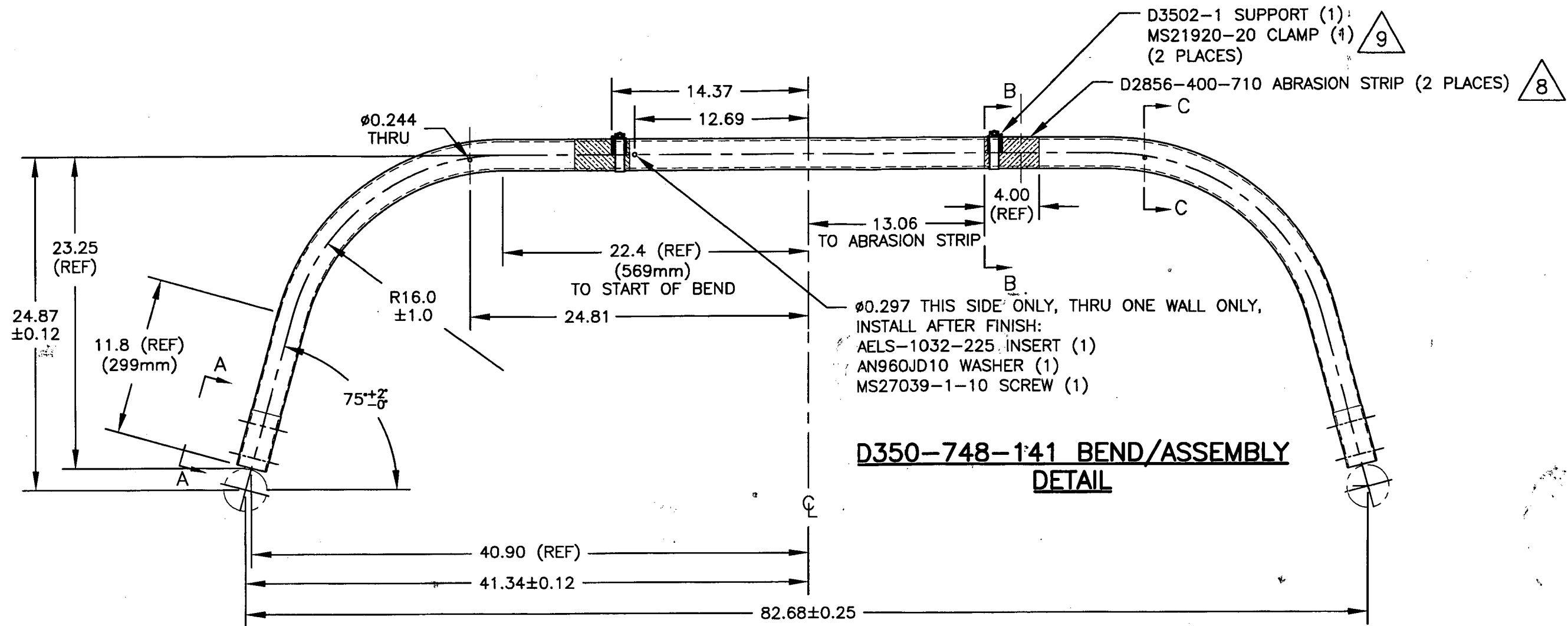
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

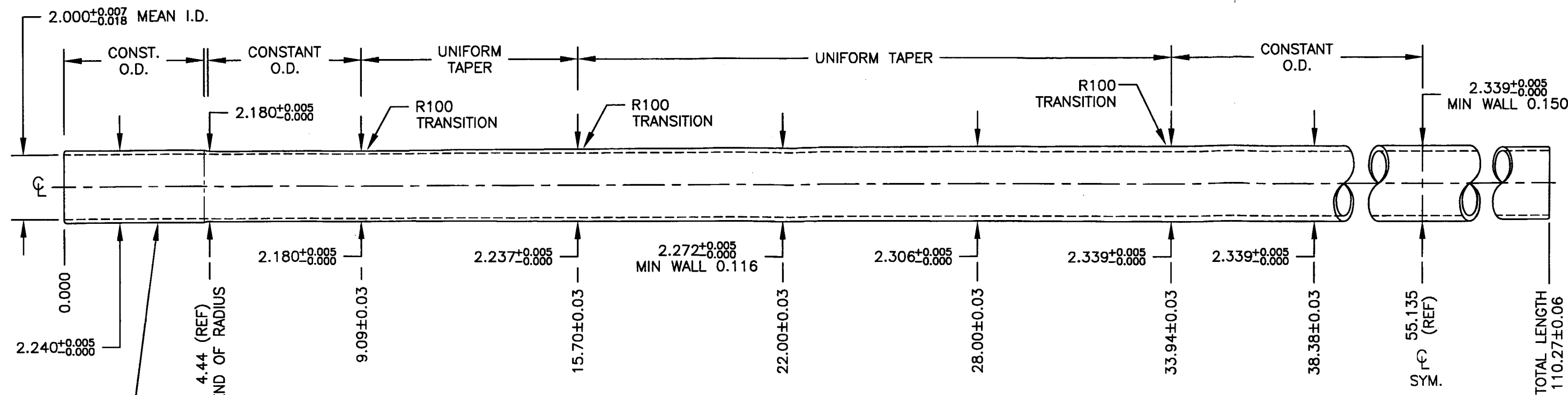


SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38491

UNDER REVIEW!
07.02/16/18
CUFF JENK, REDUCED
06.10.31

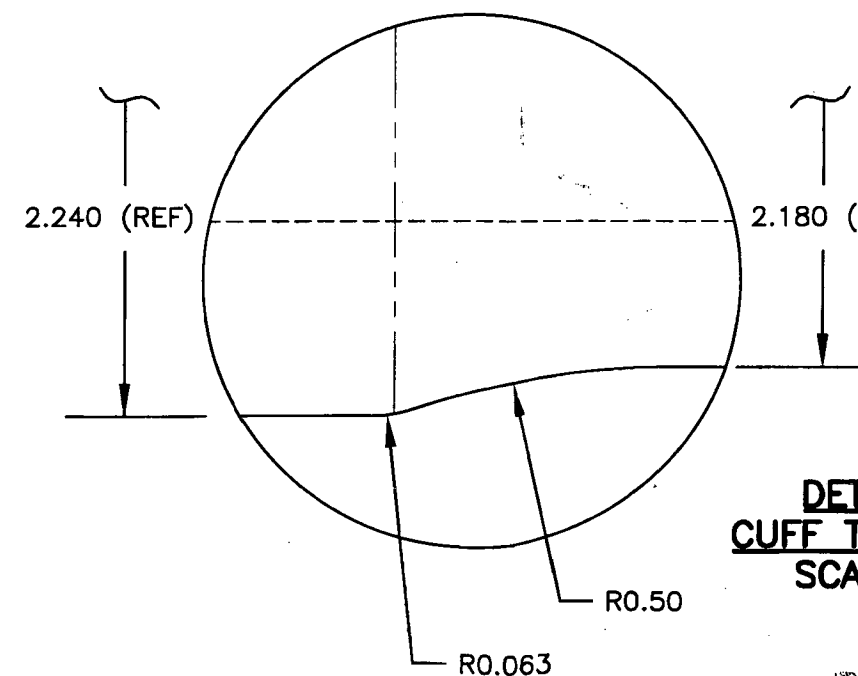
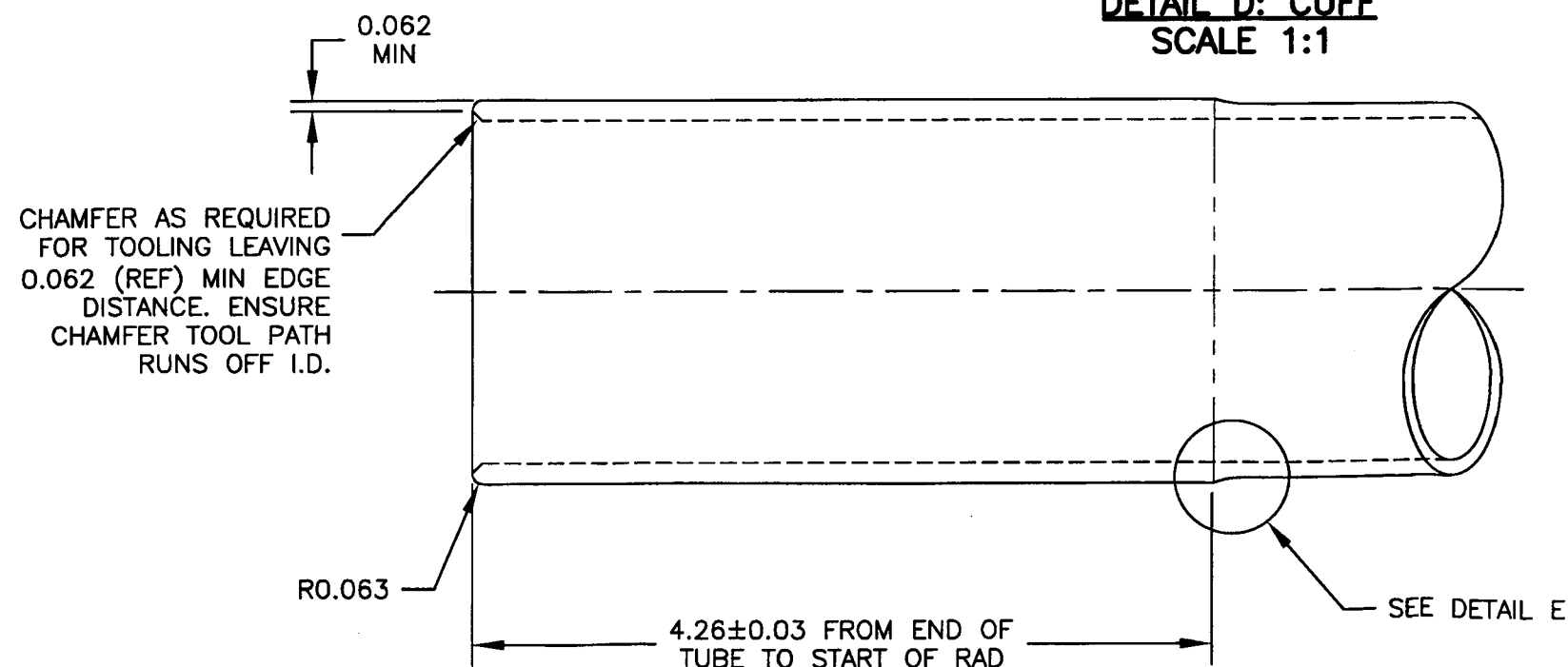
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		DATE		D350-748-141	SHEET 2 OF 3
		06.10.31		TITLE	SCALE
				CROSSTUBE (AS 350/355 HI FWD)	1:8



D350-748-141 MACHINING DETAIL

DETAIL D: CUFF SCALE 1:1



DETAIL E: CUFF TRANSITION SCALE 9:1

RELEASED

06.10.31

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WORK ORDER
No. 38491

UNDER REVIEW

07.02/16
CUFF TRANSITION
OK 07.11.22

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DESIGN

DRAWN BY

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.
D350-748-141

REV. D

DATE

TITLE

SCALE

06.10.31

CROSSTUBE (AS 350/355 HI FWD)

1:3

SHEET 3 OF 3

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Oct-17-2008

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 80589

INVOICE #: 41382

**CONTRACT OR
PURCHASE ORDER #** 00007326

DESCRIPTION: KID

QTY 1

P/N # d350-748-101

S/N # B38491

**MPI IAW ASTM-E-1444. CADMIUM PLATE IAW AMS-QQ-P-416B
TYPE 2 CLASS 2. BAKE HEAT CHARTS #9725 AND 9741.**

S
09/10/22

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:

Date: Tuesday, 08/04/2008 4:58:17 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/355 AS X-TUBE FWD
 Job Number : 38491
 Estimate Number : 12485
 P.O. Number : Part Number : D350748101
 This Issue : 08/04/2008 S.O. No. : Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : LANDING GEAR Drawing Revision : B
 Previous Run : 38490 Material :
 Written By : Due Date : 30/06/2008 Qty: 1 Um: Each
 Checked & Approved By : JLD 08.4.09
 Comment : Est Rev:A New Issue 06-07-05 JLM
 Est Rev:B Update qty of MS21042L5 06-09-12 KJ
 Est Rev:C Rev B 07-11-15 DD
 Est Rev D Combined manufacturing 08.04.02 EC verified by:
 DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.4.23



Comment: Photocopy bluefile & type labels per PPPD350-748-101 CHG001

2.0 D350748141TRN CROSSTUBE TURNING DETAIL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 CROSSTUBE TURNING DETAIL
 batch _____

3.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE
 Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT _____

4.0 QC15 DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

5.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs,
 Set-up drill table as per QSI 010

2-Deburr